

Tuesday, January 17, 2017 11:19:58 AM

Page 1

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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																								OTHER :																																							

Tuesday, January 17, 2017 11:19:58 AM

Page 2

Packaging

10x207-039

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Work Order ID 155468***155468***

Page 3

Tuesday, January 17, 2017 11:19:58 AM

Item ID: 647.0110

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Roof Doubler

Start Date: 1/20/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/27/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.03

Quality Control

1.5 mils thickness primer

CCK
SA 088

MAR 13 2017

190

Identify as per dwg & Stock Location

0.00

190

Packaging

Memo

0.02

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

10X

DAS
26
9-89

MAR 14 2017

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.17

Quality Control

17/3/15

DAS
21
9-89

MAR 14 2017

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Picklist Print

Tuesday, January 17, 2017 11:19:57 AM

Page 1

Work Order ID: 155468

155468

Parent Item: 647.0110

647 0110

Parent Item Name: Roof Doubler

Start Date: 1/20/2017

Required Date: 1/27/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		110	sf	138.0500	2.466	25.9579			
M2024T3S 063									**				
2024-T3 .063 sheet									25.6				

DAS
46
9-89

17/02/01

Location

Loc Qty

Loc Code

MAT

11.3

m135512

11.3

MAT009

126.75

m134640

51

m135612

27.75

m136492

48

28.7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

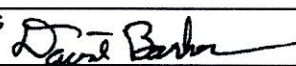
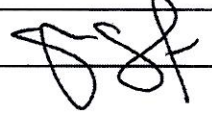
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FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	14.06.26	New Issue	KJ	

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03985				SHEET 1 OF 2	
	DWG NO. 647.0100	REV: A	PREPARED BY J. BECKER	DATE: 7/15/13	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: SHEET METAL					
	APPROVED BY: ENGR 	MFG 	QC 	EFF. NEXT ORDER		
TRANSACTION CODES (TC): A-ADD R-REVISE C-CREATE D-DELETE	REASON: REVISED NOTE 2. ADDED 647.0117					

IS

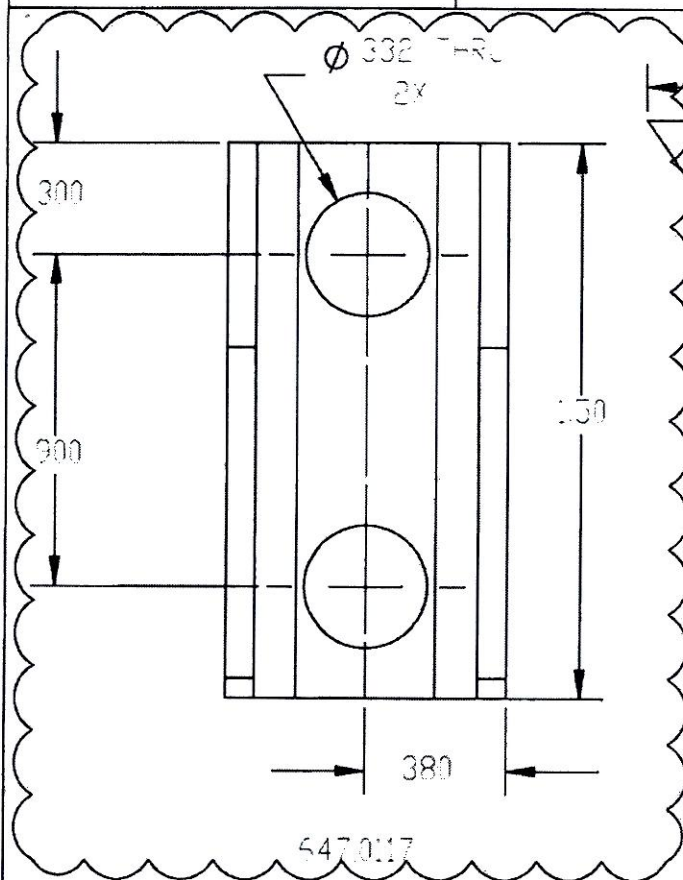
NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
- 2 FINISH: IAW MPP-172 ANODIZE IAW SECTION 2.1, PRETREATMENT IAW SECTION 3.1 AND PRIMER IAW SECTION 4.1.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.
- 7 OTHER DIMENSIONS SAME AS 647.0112.

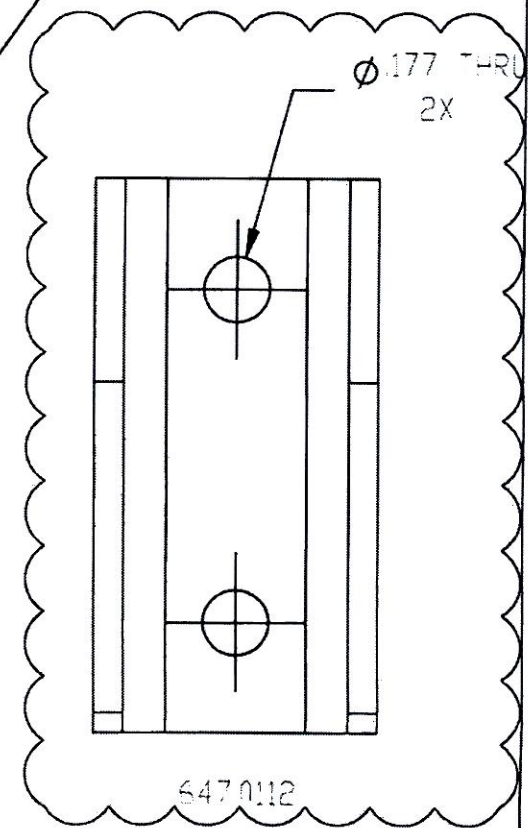
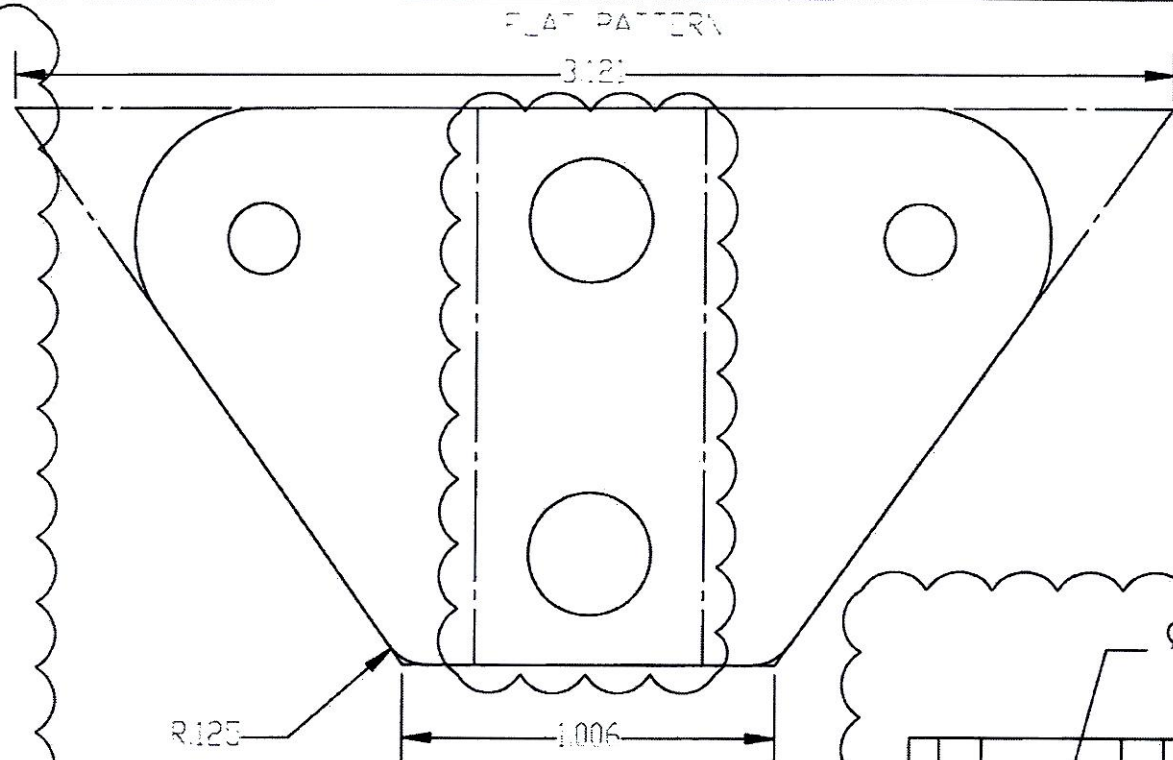
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155468 MLJ
1701-17

SHEET 1, ZONE D1 IS:

C	647.0117	STRUT BRACKET		△	△
F/N	TC	PART NUMBER	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:			CHANGE CATEGORY	DER REVIEW REQUIRED	
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM			☐ MAJOR ☒ MINOR	☐ YES ☒ NO	



6470117

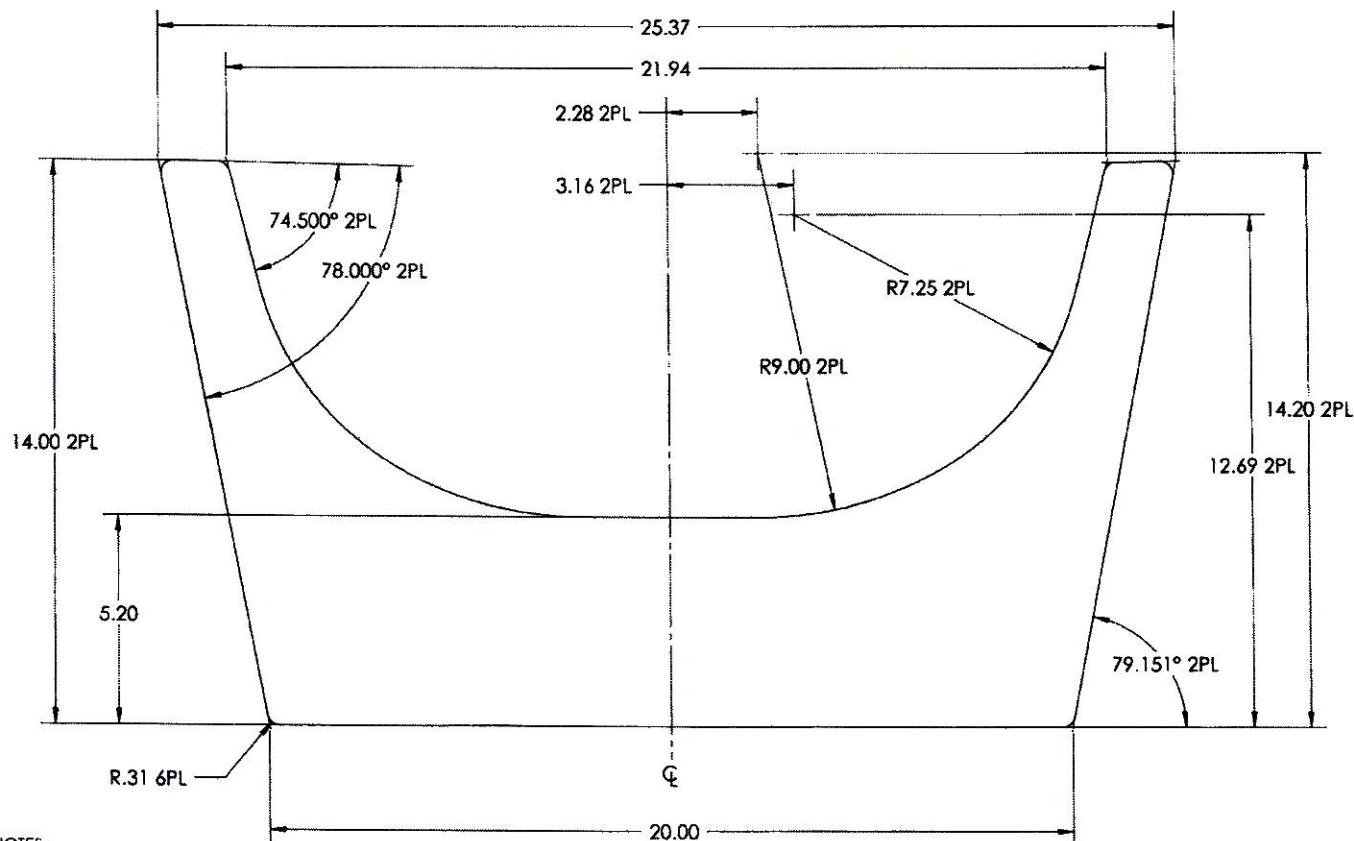


6470112

SHEET 3, ZONE B2-4 IS:

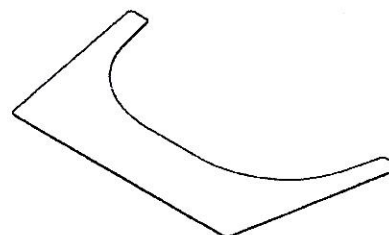
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REV	DESCRIPTION	DATE	APPROVED
1	LAST PRODUCTION REVISION PPS		N/C
2	NEW RELEASE	05/28/09	P. BRAYD
3	INCORPORATED ECH 62777 05/24/09	04/26/11	P. BRAYD



NOTES:

- 1 MATERIAL: ALUMINUM 2024-T3 PFR AMS-QQ-A-250/4.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 MATERIAL: 304 SS IAW AMS 5643.
- 6 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



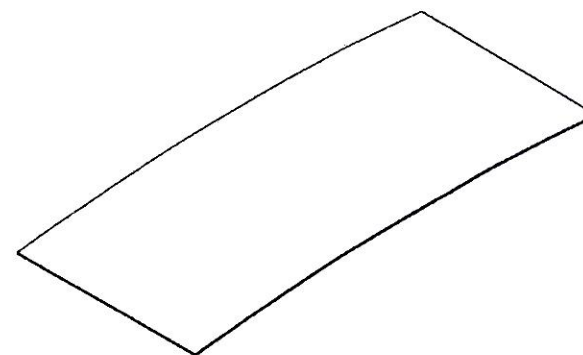
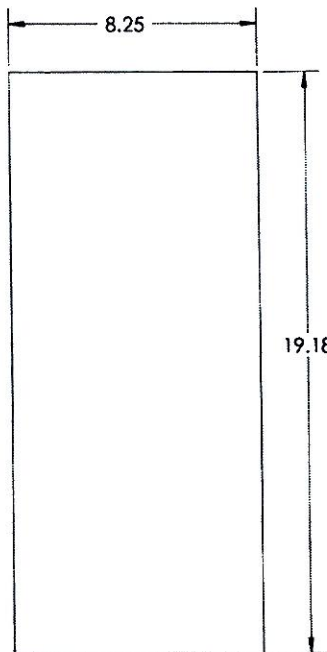
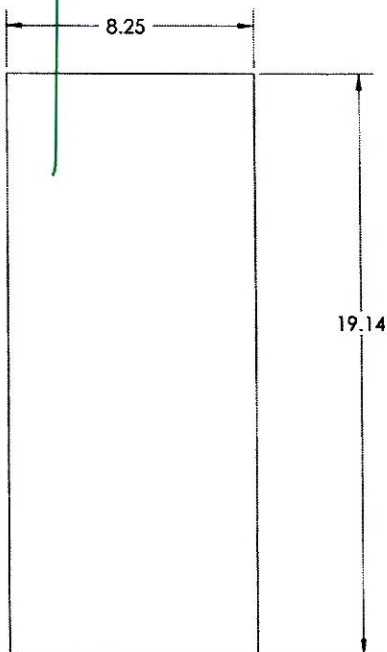
647.0110

UNINCORPORATED ECN(s)

03985

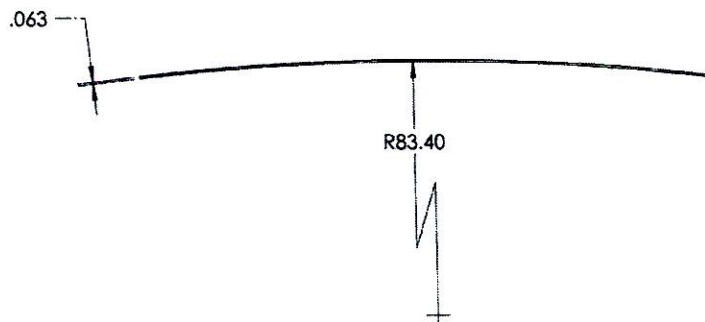
QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
		647.0116	DOUBLER	△	△
		647.0115	CLIP	△	△
		647.0114	CLIP	△	△
		647.0113	STRUT DOUBLER	△	△
		647.0112	STRUT BRACKET	△	△
		647.0111	PANEL	△	△
		647.0110	ROOF DOUBLER	△	△
PARTS LIST			APICAL INDUSTRIES		
NEXT ASSY (S)			2608 TEMPLE HEIGHTS DR.		
646.9500			OCEANSIDE, CA. 92056-3512 (76)		
ORIGINAL DATE: 05-28-09			SHEETMET		
DRAWN BY: J. P. BRAYD			SCALE: NONE		
DRAWING APPROVAL: P. BRAYD			DWG. NO. 64		
CONTRACT NO.			SCALE: NONE		
UNLESS OTHERWISE SPECIFIED			DWG. NO. 64		
DIMENSIONS ARE IN INCHES			SCALE: NONE		
TOLERANCES ARE:			SCALE: NONE		
2 PLACE DECIMALS ± .01			SCALE: NONE		
3 PLACE DECIMALS ± .001			SCALE: NONE		
ANGLES: 1°			SCALE: NONE		

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647.0111

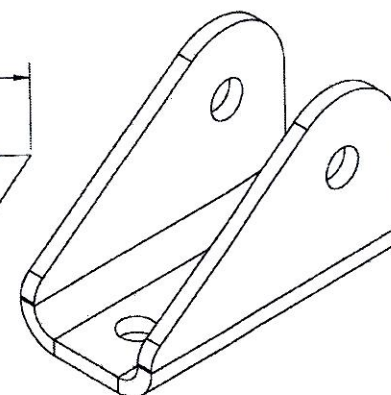
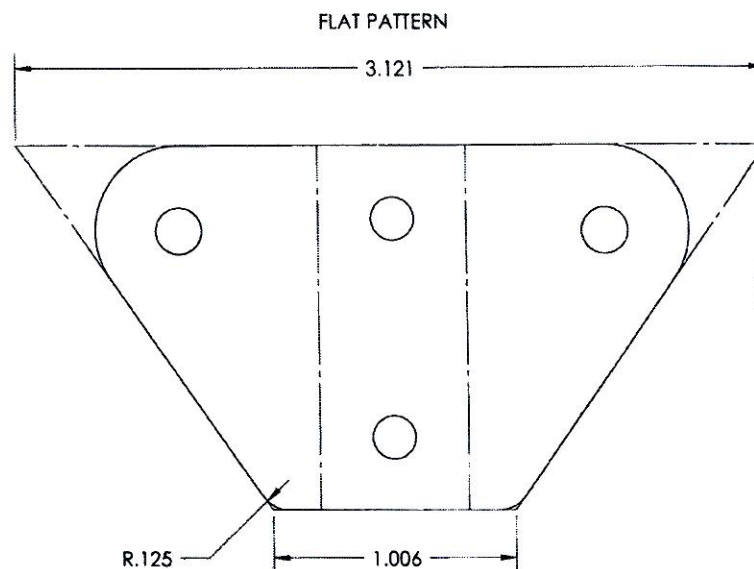
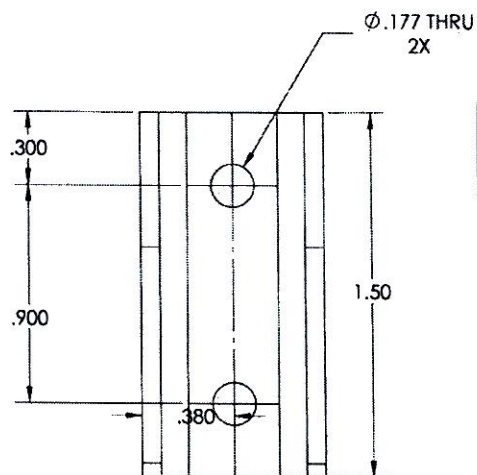
FLAT PATTERN



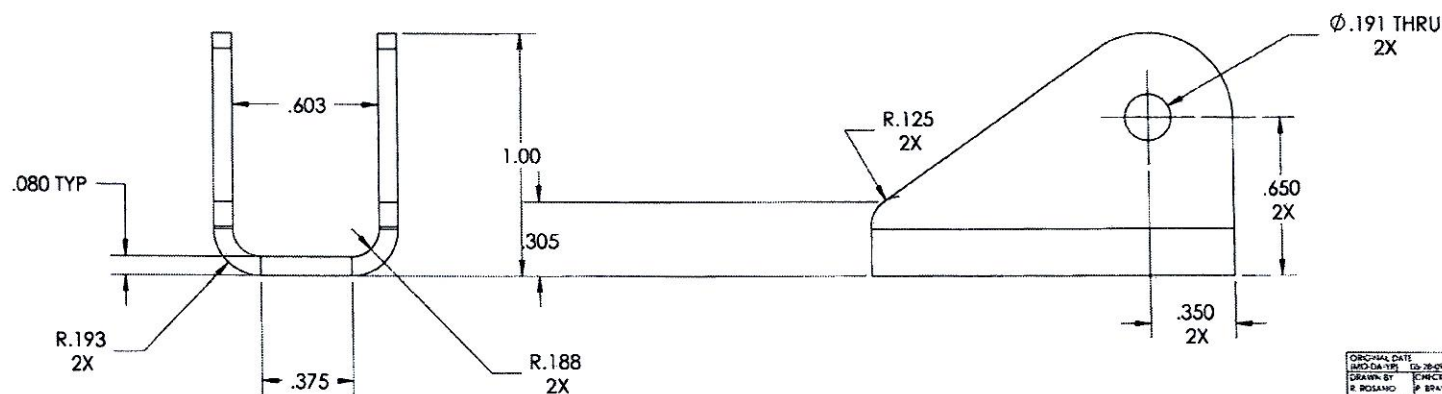
ORIGINAL DATE 01-28-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWN BY R. HOSKINS	CHECKED P. BRAVO		
DRAWING APPROVAL P. BRAVO			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°		SHEET METAL SCALE: NONE	REV A
SHEET 2 OF 6		Dwg. No. 647.0100	

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REVISE			
REV.	DESCRIPTION	DATE	APPROVED



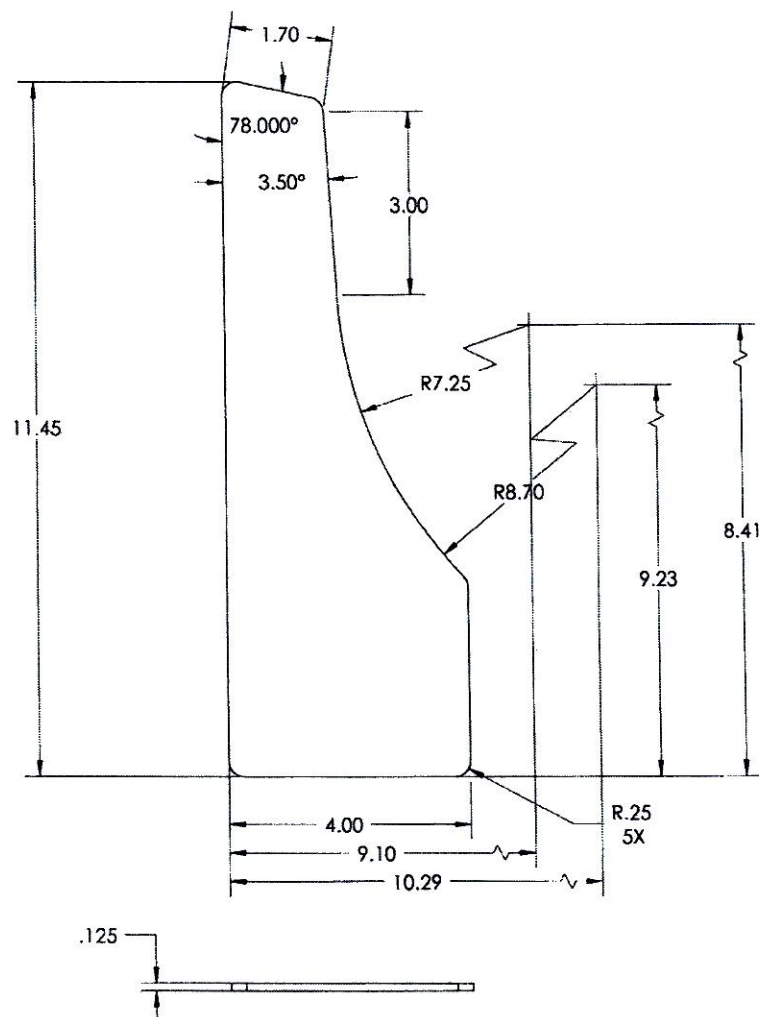
647.0112



ORIGINAL DATE JUN 04 1998		APICAL INDUSTRIES	
DRAWN BY R. ROSANO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAVO		SHEETMETAL	
CONTRACT NO.		647.0100	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		REV. 1: AGE CODE B 07M26	REV. A
SCALE: NONE		SHEET 3 OF 6	

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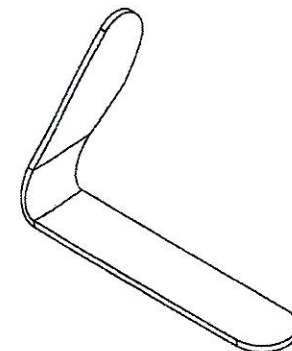
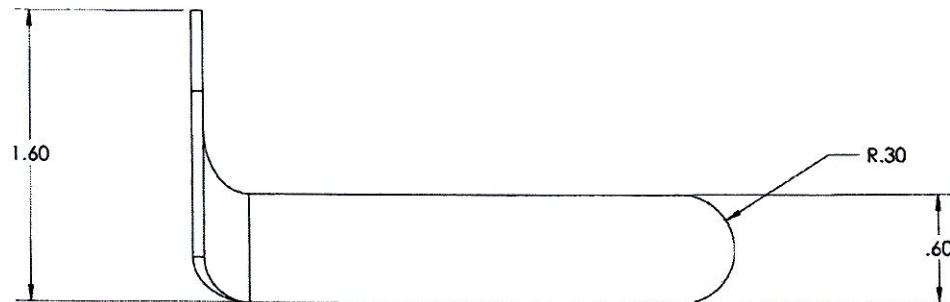
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



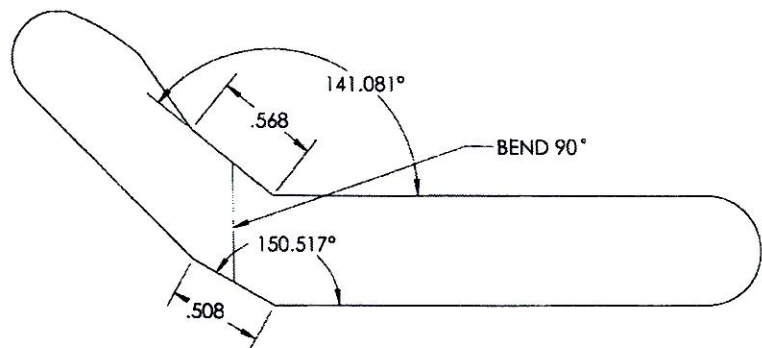
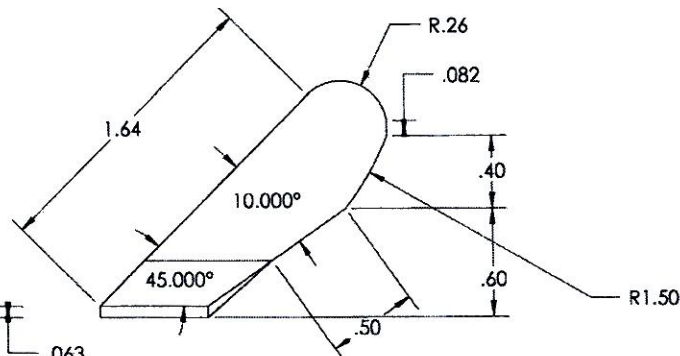
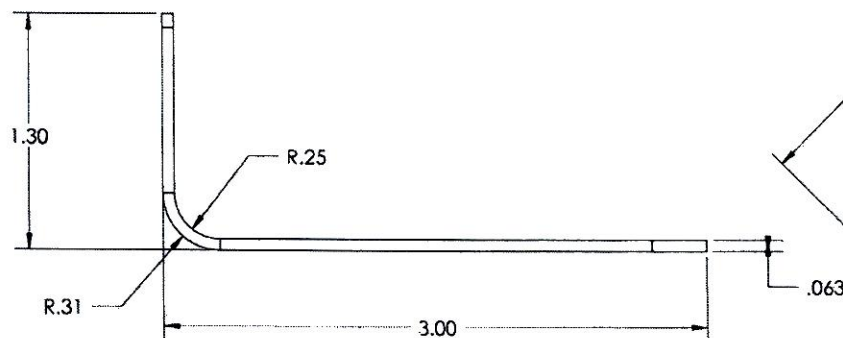
ORIGINAL DATE: 05-28-09 DRAWN BY: P. ROSANO CHECKED BY: P. BRAVO DRAWING APPROVAL: P. BRAVO CONTRACT NO:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± 1°		SHEETMETAL	
REV	CAGE CODE	DWG NO	REV
B	07M26	647.010J	A
SCALE: NONE		SHEET 4 OF 6	

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



647.0114 SHOWN
647.0115 OPPOSITE

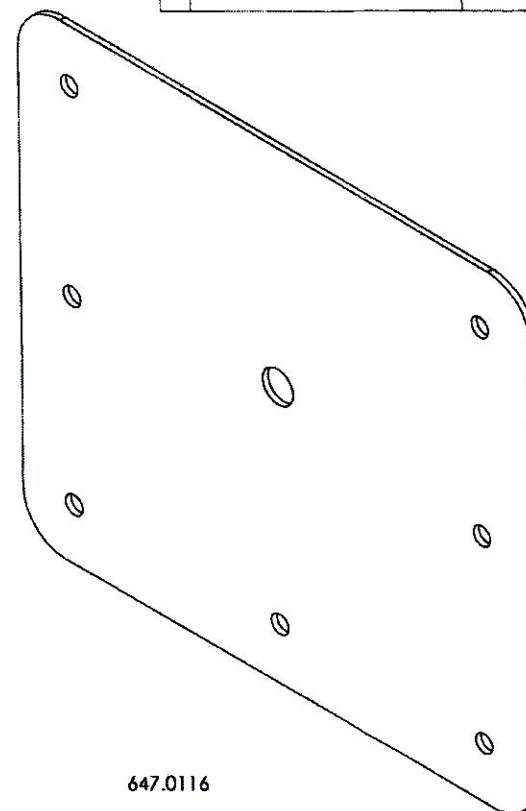
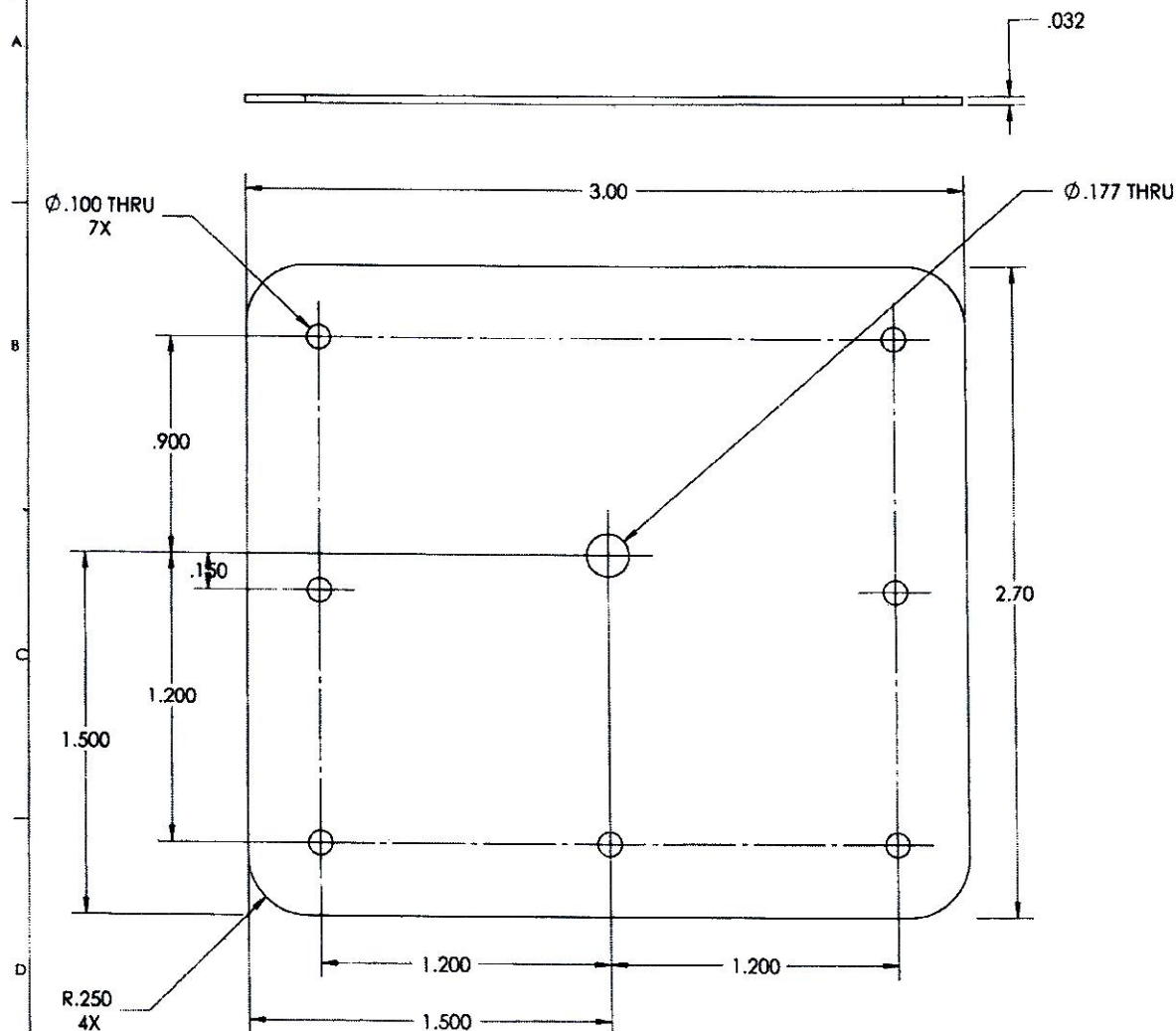


FLAT PATTERN

ORIGINAL DATE 10/01/18 05:28:01		APICAL INDUSTRIES	
DRAWN BY R. ROSANO	CHECKED P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		SHEETMETAL	
CONTRACT NO.		SCALE NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .01 ANGLES DECIMALS ± .005 ANGLES ± .5°		SIZE B	DWG NO. 647.0100
		REV. A	SHEET 5 OF 6

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



ORIGINAL DATE 10/01/88 DRAWN BY P. ROSANO P. BRAVO DRAWING APPROVAL P. BRAVO CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°		SHEETMETAL	
SUR	CAGE CODE	DWG. NO.	REV
B	07MA26	647.0100	A
SCALE NONE		SHEET 6 OF 6	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35353**

Purchase Order Date 2/17/2017
PO Print Date 2/22/2017

Page Number 3 of 6

Order From :
A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

VC-ATG001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Total: \$65.50

155468

DAS
38
9-89

647.0110 ROOF
DOUBLER REV. A

3/7/2017

Yes

2/7/2017

10.00

\$43.00

\$430.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N

Line Total: \$430.00

8 154535

647.1712 GUSSET REV. E

3/7/2017

Yes

2/7/2017

4.00

\$12.65

\$50.60

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N

Line Total: \$50.60

9 155355

647.3914 BREAKAWAY
TIP REV. C

3/7/2017

Yes

2/7/2017

6.00

\$11.55

\$69.30

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-PRF-23377 TYPE I CLASS N

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

2/22/2017



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913024

Date: 08-Mar-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
10 ea	Part: 647.0110 Roof Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20726	Rev: A Line: 7	SP17-039.
4 ea	Part: 647.1712 Gusset Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20727	Rev: E Line: 8	
6 ea	Part: 647.3914 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class 2 Primer per MIL-PRF-23377K, Type I, Class N Job: 20728	Rev: C Line: 9	
DATE: 03/03/2017 CERTIFIED SIGNATURE: RECEIVER SIGNATURE: _____ Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. CERTIFICATE OF CONFORMANCE A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS. MADE IN CANADA.			